

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

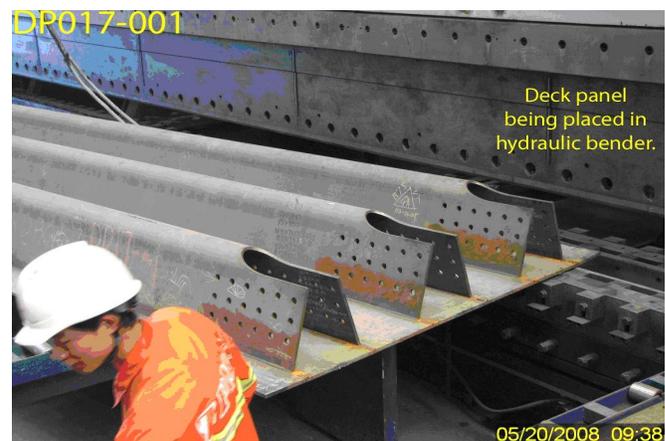
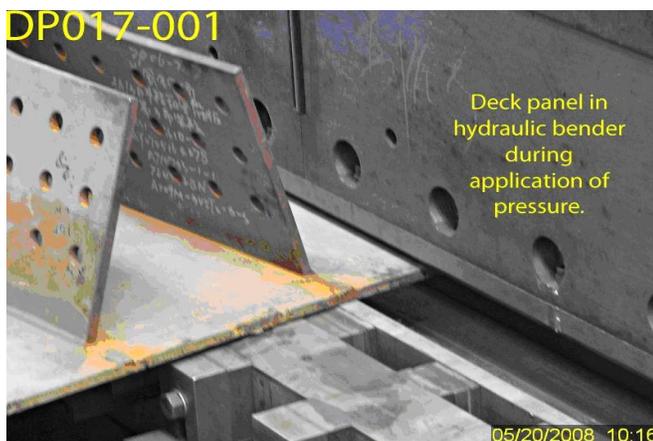
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, PRC**Report No:** NCR-000135**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 20-May-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0129**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: DP017-001
Procedural	Procedural	Description: OBG Deck Panel	

Reference Description: Unapproved straightening of deck panel DP017-001**Description of Non-Conformance:**

The Contractor performed straightening of members using means that have not been approved by the Engineer.

The Contractor placed the deck panel DP017-001 into a hydraulic press plate bender and applied pressure to straighten the outer edge of the panel. This straightening of the deck panel plate was not approved by the Engineer as required by AWS D1.5, Section 3.7.3 which states, "Members distorted by welding shall be straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the Engineer."

**Applicable reference:**

AWS D1.5, Section 3.7.3: "Members distorted by welding shall be straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the Engineer."

Who discovered the problem: QA Inspector William Clifford**Name of individual from Contractor notified:** ABFJV QC Inspector Warren Buehler**Time and method of notification:** Approximately 7:48 hours by phone on 5-21-08.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: Approximately 15:00 hours verbally

QC Inspector's Name: ZPMC QC Inspector Wang Sai Fa

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Comments:

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, 916-227-5719, who represents the Office of Structural Materials for your project.

Inspected By:	Lowry,Patrick	SMR
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Reviewed By:	Lowry,Patrick	SMR
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DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 30-May-2008

Contract No: 04-0120F4
04-SF-80-13.2 / 13.9

Dear: Mr. Charles Kanapicki

Job Name: SAS Superstructure

Attention: Mr. Dave Williams Consultant

Document No: 05.03.06-000110

Subject: NCR No. ZPMC-0129

Reference Description: Unapproved straightening of deck panel DP017-001

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

- Material or Workmanship not in conformance with contract documents.
- Quality Control (QC) not performed in conformance with contract documents.
- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved.

Material Location: OBG **Lift:**

Remarks:

The Contractor performed straightening of members using means that have not been approved by the Engineer. The Contractor placed the deck panel DP017-001 into a hydraulic press plate bender and applied pressure to straighten the outer edge of the panel. This straightening of the deck panel plate was not approved by the Engineer as required by AWS D1.5, Section 3.7.3 which states "Members distorted by welding shall be straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the Engineer."

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance to prevent future occurrences.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0129

cc: Rick Morrow, Gary Pursell, Brian Boal, Jason Tom, Ching Chao

File: 05.03.06

NCR PROPOSED RESOLUTION

To: CALTRANS - SAS Superstructure
333 Burma Road
Oakland CA 94607

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000110

Subject: NCR No. ZPMC-0129

Dated: 10-Sep-2008

Contract No.: 04-0120F4
04-SF-80-13.2 / 13.9

Job Name: SAS Superstructure

Document No.: ABF-NPR-000128 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: The ZPMC work crew in this repair bay was unaware of the requirement as well as the onsite ZPMC CVM. If this type of repair is required in the future, ZPMC will require Engineers approval.

ABF JV has informed ZPMC of this non-conformance, the work crew in this repair bay was unaware of the requirement as well as the onsite ZPMC CVM. If this type of repair is required in the future, ZPMC will require Engineers approval.

Submitted by:

Attachment(s): ABF-NPR-000128R00

Caltrans' comments:

Status: AAP

Date: 28-Sep-2008

The response is acceptable, but the Non-Conformance is not closed.

Please provide documentation to identify the requirements for straightening, and confirm that the distortion has been corrected to within acceptable dimensional tolerances. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0129 at that time.

Submitted by: Wright, Doug

Date: 28-Sep-2008

Attachment(s):

NCR PROPOSED RESOLUTION

To: CALTRANS - SAS Superstructure
333 Burma Road
Oakland CA 94607

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000110

Subject: NCR No. ZPMC-0129

Dated: 18-Nov-2008

Contract No.: 04-0120F4
04-SF-80-13.2 / 13.9

Job Name: SAS Superstructure

Document No.: ABF-NPR-000128 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC requests closure of this NCR based on the attached documentation.

ZPMC requests closure of this NCR based on the attached documentation.

Submitted by:

Attachment(s): ABF-NPR-000128R01; close-out documents

Caltrans' comments:

Status: CLO

Date: 20-Nov-2008

The proposed resolution is acceptable. The documents requested in Rev 0 of NPR-0128 have been provided. The Department concurs that Non-Conformance ZPMC-0129 is closed.

Submitted by: Wright, Doug

Date: 21-Nov-2008

Attachment(s):



TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 11/15/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: CALTRANS NCR FOR CLOSURE

SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.B-267R1 FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000135/138(ZPMC-0129/132).
- (3) COPY OF THE HEAT STRAIGHT CHECKING REPORT

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:

J. Acord
PLAN HOLDER

11-15-08
DATE

ABF
COMPANY

PHONE NO.

PLAN NUMBER: N/A
#R787-QCP-102



No. B-267R1

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-11-15

REGARDING: NCR-000135/138 (ZPMC-0129/132)

With this letter of response, ZPMC requests closure for Caltrans NCR-000135/138 (ZPMC-0129/132). As the comments from caltrans: please provide documentation to identify the requirements for straightening, and confirm that the distortion has been corrected to within acceptable dimensional tolerances. So we submit the documentation as follow, they can prove the parameter both before and after heat straighten.

So ZPMC considers NCR-000135/138 (ZPMC-0129/132) can be closed.

Please check the attached documentation for acceptance and close the NCR-000135/138 (ZPMC-0129/132).

ATTACHMENT:

NCR-000135/138 (ZPMC-0129/132)

The heat straight checking report

zhang shuangbao

2008.11.15

ABF QCM
17 Nov. 08



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 30-May-2008

Contract No: 04-0120F4
04-SF-80-13.2 / 13.9

Dear: Mr. Charles Kanapicki
Attention: Mr. Dave Williams Consultant

Job Name: SAS Superstructure

Subject: NCR No. ZPMC-0129

Document No: 05.03.06-000110

Reference Description: Unapproved straightening of deck panel DP017-001

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

- Material or Workmanship not in conformance with contract documents.
- Quality Control (QC) not performed in conformance with contract documents.
- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved.

Material Location: OBG

Lift:

Remarks:

The Contractor performed straightening of members using means that have not been approved by the Engineer. The Contractor placed the deck panel DP017-001 into a hydraulic press plate bender and applied pressure to straighten the outer edge of the panel. This straightening of the deck panel plate was not approved by the Engineer as required by AWS D1.5, Section 3.7.3 which states "Members distorted by welding shall be straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the Engineer."

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance to prevent future occurrences.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0129

cc: Rick Morrow, Gary Pursell, Brian Boal, Jason Tom, Ching Chao

File: 05.03.06

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 (707) 649-5453
 (707) 649-5493

Contract #: 04-0120F4
 Cty: SF/ALA Rte: 80 PM: 13.2/13.9
 File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, PRC

Report No: NCR-000135

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 20-May-2008

Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

NCR #: ZPMC-0129

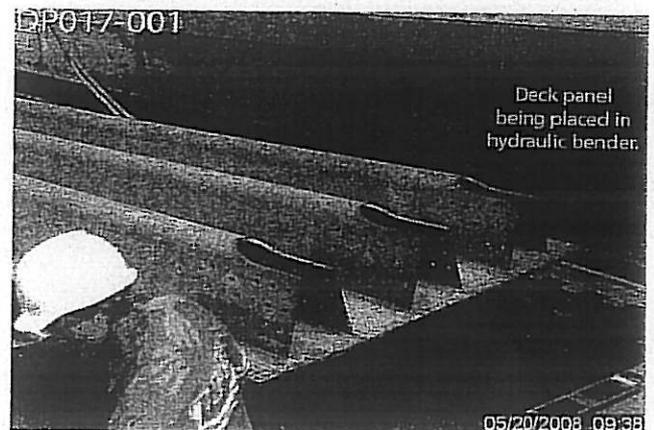
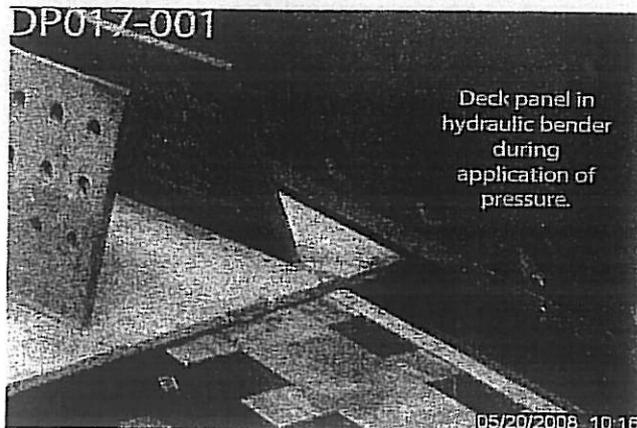
Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: DP017-001
 Procedural Procedural Descriptor: OBG Deck Panel

Reference Description: Unapproved straightening of deck panel DP017-001

Description of Non-Conformance:

The Contractor performed straightening of members using means that have not been approved by the Engineer. The Contractor placed the deck panel DP017-001 into a hydraulic press plate bender and applied pressure to straighten the outer edge of the panel. This straightening of the deck panel plate was not approved by the Engineer as required by AWS D1.5, Section 3.7.3 which states, "Members distorted by welding shall be straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the Engineer."



Applicable reference:

AWS D1.5, Section 3.7.3: "Members distorted by welding shall be straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the Engineer."

Who discovered the problem: QA Inspector William Clifford

Name of individual from Contractor notified: ABFJV QC Inspector Warren Buehler

Time and method of notification: Approximately 7:48 hours by phone on 5-21-08.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: Approximately 15:00 hours verbally

QC Inspector's Name: ZPMC QC Inspector Wang Sai Fa

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Comments:

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, 916-227-5719, who represents the Office of Structural Materials for your project.

Inspected By: Lowry,Patrick

SMR

Reviewed By: Lowry,Patrick

SMR



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 30-May-2008

Contract No: 04-0120F4
04-SF-80-13.2 / 13.9

Dear: Mr. Charles Kanapicki
Attention: Mr. Dave Williams Consultant
Subject: NCR No. ZPMC-0132

Job Name: SAS Superstructure
Document No: 05.03.06-000113

Reference Description: Unapproved Mechanical Straightening

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

- Material or Workmanship not in conformance with contract documents.
- Quality Control (QC) not performed in conformance with contract documents.
- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved.

Material Location: OBG

Lift:

Remarks:

The Contractor performed straightening of members using means that have not been approved by the Engineer. The Contractor placed the deck panel DP051-001 into a hydraulic press plate bender and applied pressure to straighten the outer edge of the panel. This straightening of the deck panel plate was not approved by the Engineer as required by AWS D1.5, Section 3.7.3 which states, "Members distorted by welding shall be straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the Engineer."

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance to prevent future occurrences.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0132

cc: Rick Morrow, Gary Pursell, Brian Boal, Jason Tom, Ching Chao

File: 05.03.06

DEPARTMENT OF TRANSPORTATION
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Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.25B



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, PRC

Report No: NCR-000138

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 28-May-2008

Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

NCR #: ZPMC-0132

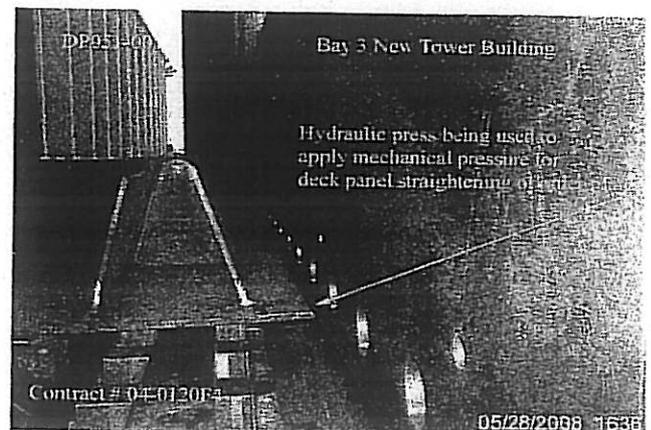
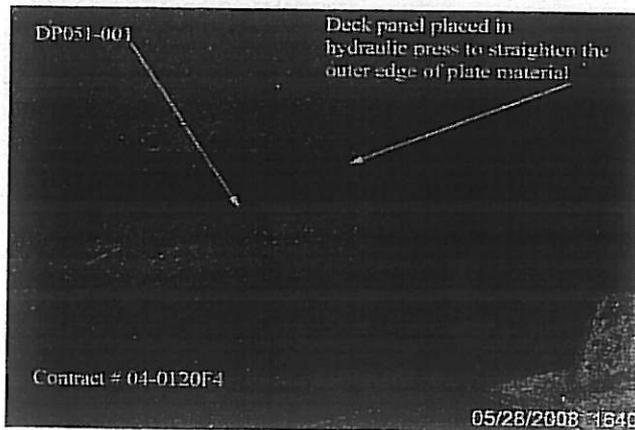
Type of problem:

Welding Concrete Other
Welding Curing Procedural Bridge No: 34-0006
Joint fit-up Coating Other Component: DP051-001
Procedural Procedural Descriptor: OBG Deck Panel

Reference Description: Unapproved Mechanical Straightening

Description of Non-Conformance:

The Contractor performed straightening of members using means that have not been approved by the Engineer. The Contractor placed the deck panel DP051-001 into a hydraulic press plate bender and applied pressure to straighten the outer edge of the panel. This straightening of the deck panel plate was not approved by the Engineer as required by AWS D1.5, Section 3.7.3 which states, "Members distorted by welding shall be straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the Engineer."



Applicable reference:

AWS D1.5, Section 3.7.3: "Members distorted by welding shall be straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the Engineer."

Who discovered the problem: QA Inspector Roscoe Dixon

Name of individual from Contractor notified: ABFJV QC Inspector David Larue

Time and method of notification: Approximately 1700 hours by phone on 5-28-08

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: Verbally at 1415 hours on 5-29-08

QC Inspector's Name: ZPMC QC Inspector Wang Lu approximately 1700 hours in person

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Comments:

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, 916-227-5719, who represents the Office of Structural Materials for your project.

Inspected By: Velasco, Abifhram

SMR

Reviewed By: Lowry, Patrick

SMR



美国钢桥钢板平整度火工校正检查记录卡

The report of steel plate heat straightening process checking

工程编号 The serial no. of project:	2406-787	图号 The drawing no.:	DP051	构件名称 Part name:	U肋板顶板
材质 Material:	A709M-30572-X-S	炉批号 The heat no. of plate:	A714478	桥段名称 Section name:	第三吊钩梁
移植是否正确 Material mark checking:	正确	轧制方向标注是否正确 Rolling direction checking:	正确	钢板编号 Plate ID:	WJ0708366219

火工校正温度控制 The temperature record of heat straightening

检查时间 Checking time:	11:00									
测量位置 Measure position:	1	2								
测量值 Measure result:	7	6								
校正前平整度测量 Flatness checking before heat straightening (mm)										
校正后平整度测量 Flatness checking after heat straightening (mm)										

整体平整度/筋板垂直度是否合格
Heat straightening result:

Acc

检验员
QC inspector:

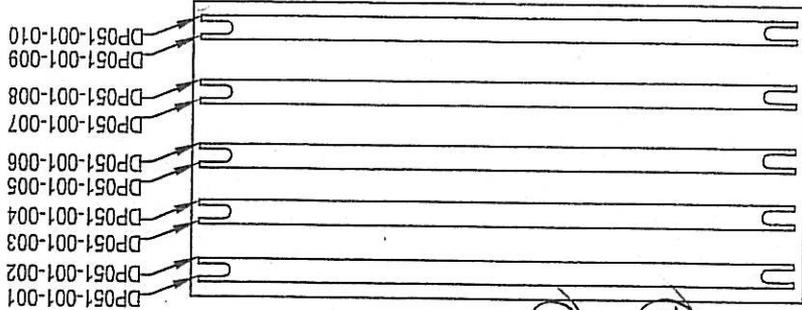
Summer

日期
Date:

06.5.27

若校正影响焊缝, 请填写以下项目
Fill the following items if the straightening affects the weld

对应NDT报告编号 NDT report no.	UT	NDT检验员签字 NDT inspector:	日期 Date:
	MT		
	RT		



DEPARTMENT OF TRANSPORTATION

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, PRC**Report No:** NCS-000119**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 26-Nov-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0129**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Descriptor:	

Date the Non-Conformance Report was written: 20-May-2008**Description of Non-Conformance:**

The Contractor performed straightening of members using means that have not been approved by the Engineer.

The Contractor placed the deck panel DP017-001 into a hydraulic press plate bender and applied pressure to straighten the outer edge of the panel. This straightening of the deck panel plate was not approved by the Engineer as required by AWS D1.5, Section 3.7.3 which states, "Members distorted by welding shall be straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the Engineer."

Contractor's proposal to correct the problem:

The Contractor provided the straightening check documentation. However, no comments given by Contractor stating how they will prevent future occurrences of this unapproved method for straightening members. No further response given at the time Team China Construction directed METS to close the NCR.

Corrective action taken:

Closed by Caltrans Construction. METS closed the NCR based on Construction's direction.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:** Stanley Ku**Date:** 26-Nov-2008**Is Engineer's approval attached?** Yes No Email of concurrence to close NCR is on file.**Comments:**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Sang Le, who represents the Office of Structural Materials for your project.

Inspected By: Dautermann, Peter

Quality Assurance Inspector

Reviewed By: Dautermann, Peter

QA Reviewer